

Date: Monday, 22/12/2008 2:08:24 PM  
 User: ~~Melanie~~ Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: 206B BASKET LID		
Job Number	: 44222A			Part Number	: D2330043		
Estimate Number	: 11280			Drawing Number	: D2330 REVF		
P.O. Number	:			Project Number	: N/A		
This Issue	22/12/2008	S.O. No.	:	Drawing Revision	: F		
Prsht Rev.	: NC			Material	:		
First Issue	:/	Type	LARGE FAB ASSY	Due Date	15/01/2009	Qty:	1 Um: Each
Previous Run	: 40843A						
Written By	:						
Checked & Approved By	: <u>UMF 08-12-23</u>						
Comment	: Est Rev:H 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K						
	J						
	Est Rev:I 08-09-09 revF as per dwg (ecn 08-522) DD verified						
	by:EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W 
		Comment: Qty.: 30.2568 f(s)/Unit Total : 30.2568 f(s) 3/4" x 3/4" x 0.065 wall 304/316 SS tubing. Batch: <u>M110 335</u> <span style="float: right;">SAO 08-01-16</span>
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 
		Comment: LARGE FABRICATION RESOURCE 1  1-Cut D2330-1-3-9 as per Dwg D2330  2-Drill hole in D2330-3 as per Dwg D2330  3-Deburr <span style="float: right;">SAO 09-01-16</span>
3.0	D22321	Basket Hinge 
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: <input checked="" type="checkbox"/> Qty Part Number Description Batch 2 D2232-1 HINGE <u>B39454 → 2</u> <span style="float: right;">SAO 09/01/20</span>
4.0	D2329	Label Plate 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: <input checked="" type="checkbox"/> Qty Part Number Description Batch 1 D2329 Label Plate <u>B35689 → 1</u> <span style="float: right;">SAO 09/01/20</span>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/12/2008 2:08:24 PM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET LID

Job Number: 44222A

Part Number: D2330043

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D23271 Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch  
1 D2327-1 Bushing B 40390

SJ 09/01/20

6.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch  
2 D2581 Mounting Chanel B 43800

SJ 09/01/20

7.0 M304EX07516F Expanded Metal Flat SS



Comment: Qty.: 18.9000 sf(s)/Unit Total : 18.9000 sf(s)

Pick:

Qty Part Number Description Batch  
18 sf M304EX0.75-16F Expanded Metal M 110292

SAD 09-01-20

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2330 using Welding Table and corner Jig SJ

Deburr as required

A/R SS ROD Batch: M108775

SJ 09/01/20 10

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-01-26 ①

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/26 ⑩

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, -22/12/2008 2:08:25 PM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET LID

Job Number: 44222A

Part Number: D2330043

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 POWDER COATING

POWDER COATING



PRESSURE WASH BR 09-01-28



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 8:15

OVEN TEMPERATURE: 400°

FINISH TIME: 8:45

m 10996

①

Ex 09/01/28

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-01-28

②

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

44222 h

14.0 QC21

FINAL INSPECTION/W/O RELEASE



09/02/02 d

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



h 09-01-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-043	D2330-041	BASKET ASSEMBLY
X	X	D2330-043	LID ASSEMBLY
1		D2012-107	CLEVIS
2		D2232-1	HINGE
2		D2232-3	HINGE
4		D2235-1	RIB
2		D2253-1	LUG
2		D2254	GUSSET
1		D2327-1	BUSHING
1		D2327-3	BUSHING
1		D2329	LABEL PLATE
2		D2330-1	FRAME
2	2	D2330-3	FRAME
1		D2330-5	FRAME
1		D2330-7	FRAME
1	2	D2330-9	FRAME
2		D2330-11	FRAME
2		D2330-13	FRAME
1		D2330-15	FRAME
4	2	D2581	MOUNTING CHANNEL

REFERENCE ONLY  
# 44222A

RELEASED  
08-09-03-100

F

ITES:

FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065

MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F

FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: N/A

IDENTIFICATION: N/A

WEIGHT: N/A

WELD PER DART QSI 004

F	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 6 ADDED. FRAME MATERIAL THICKNESS WAS 0.060.		
E	INCORPORATED D1. D2253-1 WAS D2253 (NCR 533). KE 05.11.10		
D	MODIFIED LATCH, REDRAWN KE 99.09.14		
C	ADDED LATCH AND LABEL PLATE BK 96.05.23		
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A	DRAWING NO.	REV. F
MFG. APPR.	A	D2330	SHEET 1 OF 6
APPROVED	M	TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NTS
DATE	08.08.11		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

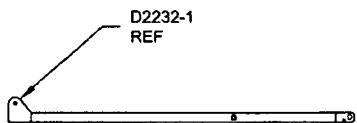
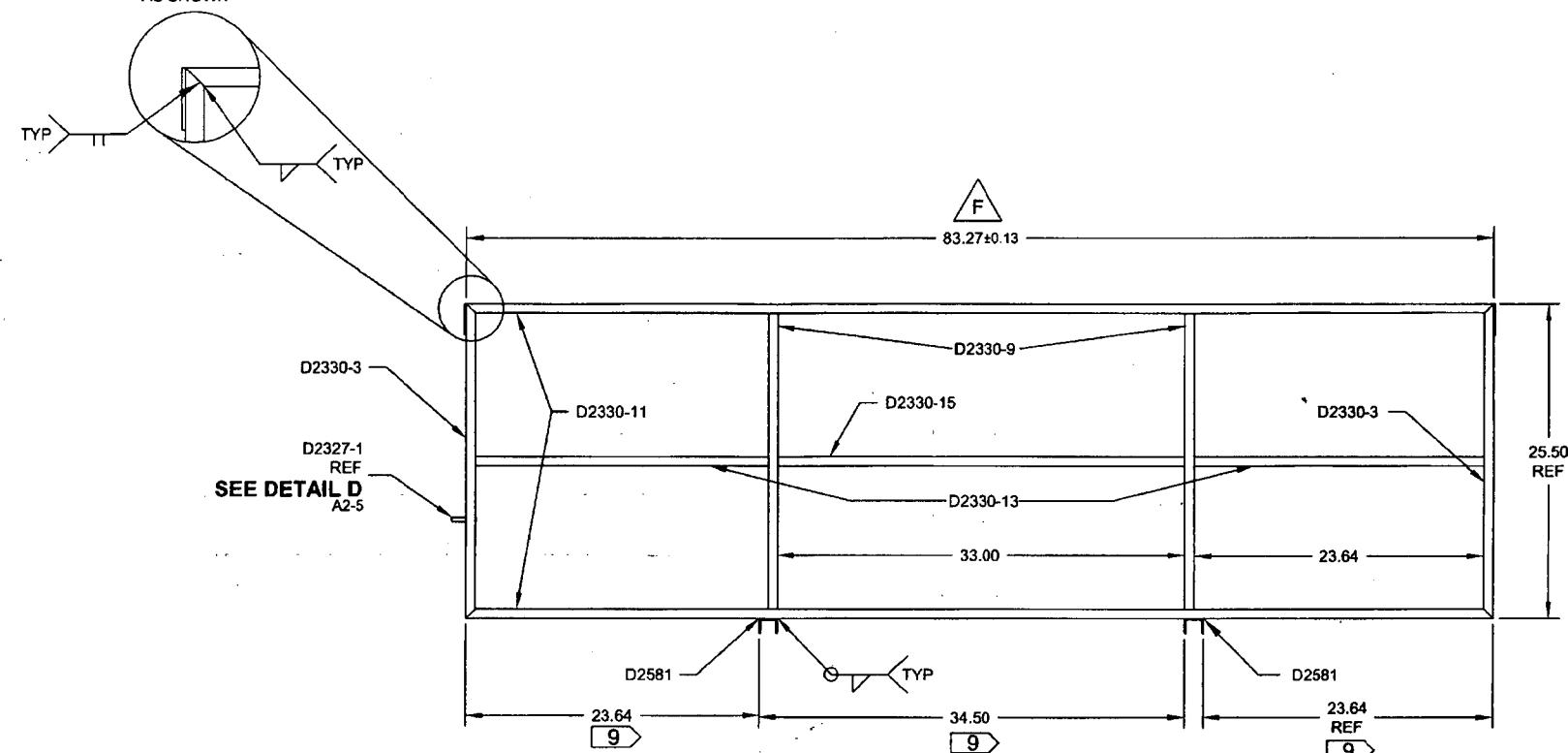
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

WELD ALL JOINTS  
AS SHOWN



A

A D6-5

D2330-043 LID FRAME

RELEASED  
08.08.11

LID FRAME NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) ALIGN WITH ADJACENT D2581 ON BASE



REFERENCE ONLY

# 44222A

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	AUS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. REV. F	
MFG. APPR.		D2330 SHEET 2 OF 6	
APPROVED		TITLE	
DE APPR.		SCALE	
DATE	08.08.11	BASKET ASSEMBLY (206B) NTS	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

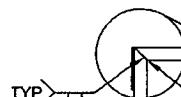
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

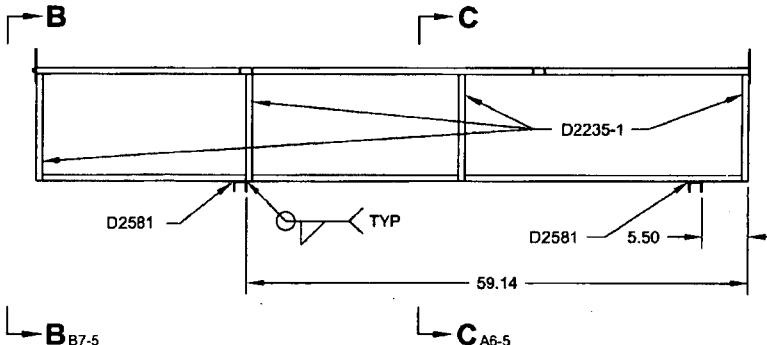
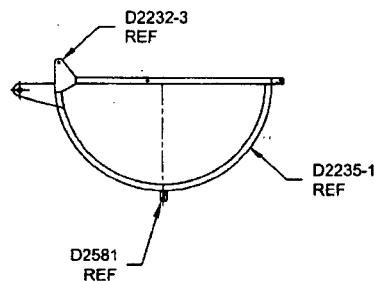
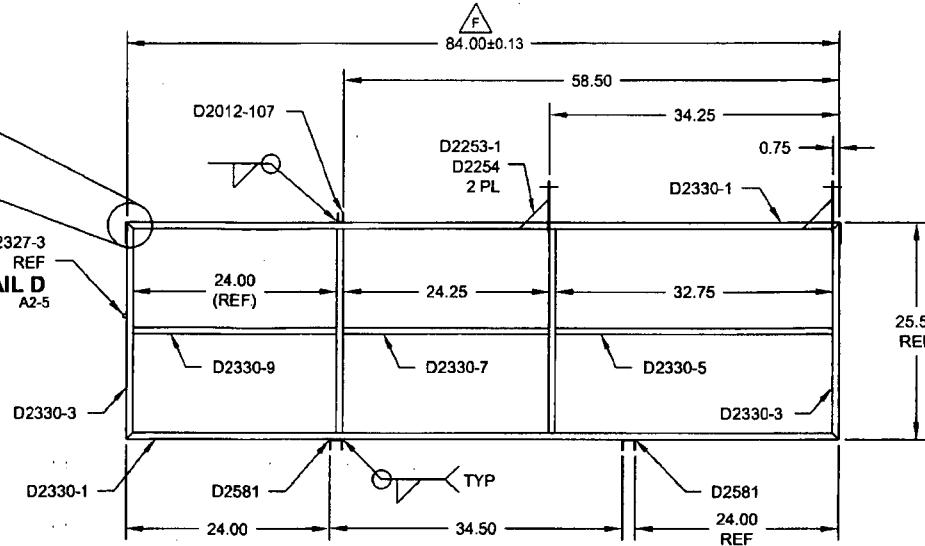
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

WELD ALL JOINTS  
AS SHOWN



D2327-3  
REF  
SEE DETAIL D  
A2-5



RELEASED  
08-09-05-10

**D2330-041 BASE FRAME ASSEMBLY**

DESIGN	B	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. REV. F	
MFG. APPR.		D2330 SHEET 3 OF 6	
APPROVED		TITLE	
DE APPR.		SCALE	
DATE	08.08.11	BASKET ASSEMBLY (206B) NTS	

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REFERENCE ONLY  
# 44222A

**BASE FRAME NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

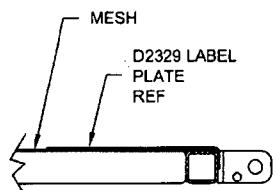
8 7 6 5 4 3 2 1

D

C

B

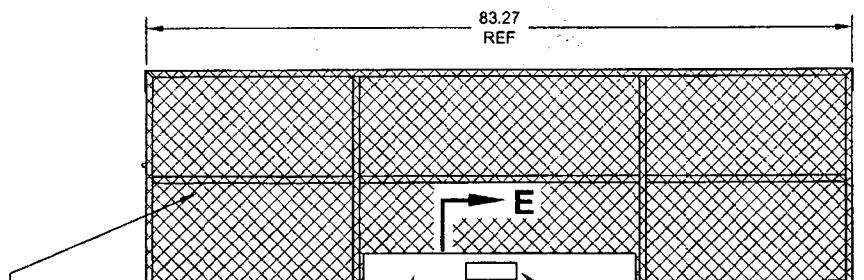
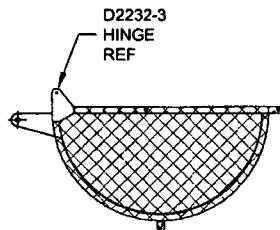
A



**SECTION E-E** C3-4  
VIEW ROTATED 90° CCW



TACK WELD EACH  
STRAND END OF  
STEEL MESH TO FRAME



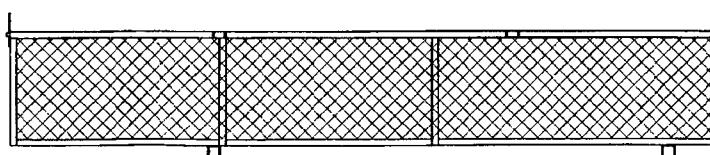
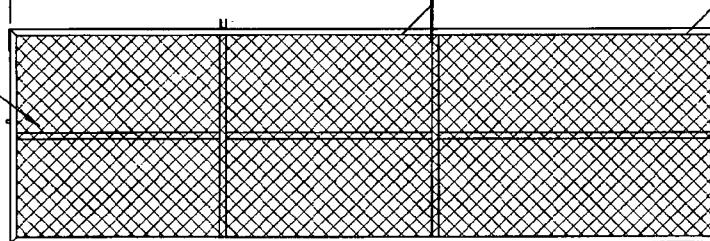
D2329 LABEL PLATE  
CENTER ON THE  
BASKET LID

**E** C3-4

REMOVE 2" X 6" SECTION  
OF MESH FROM BEHIND  
LABEL PLATE

**D2330-043 LID ASSEMBLY**

84.00  
REF



**D2330-041 BASE ASSEMBLY**

RELEASED  
08-09-05

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	ADS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	12	DRAWING NO.	REV. F
MFG. APPR.	M	D2330	SHEET 4 OF 6
APPROVED	1A	TITLE	SCALE
DE APPR.	X	BASKET ASSEMBLY (206B)	NTS
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REFERENCE ONLY  
# 44222A

**ASSEMBLY NOTES:**  
1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: N/A  
8) WELD PER DART QSI 004

13

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

8

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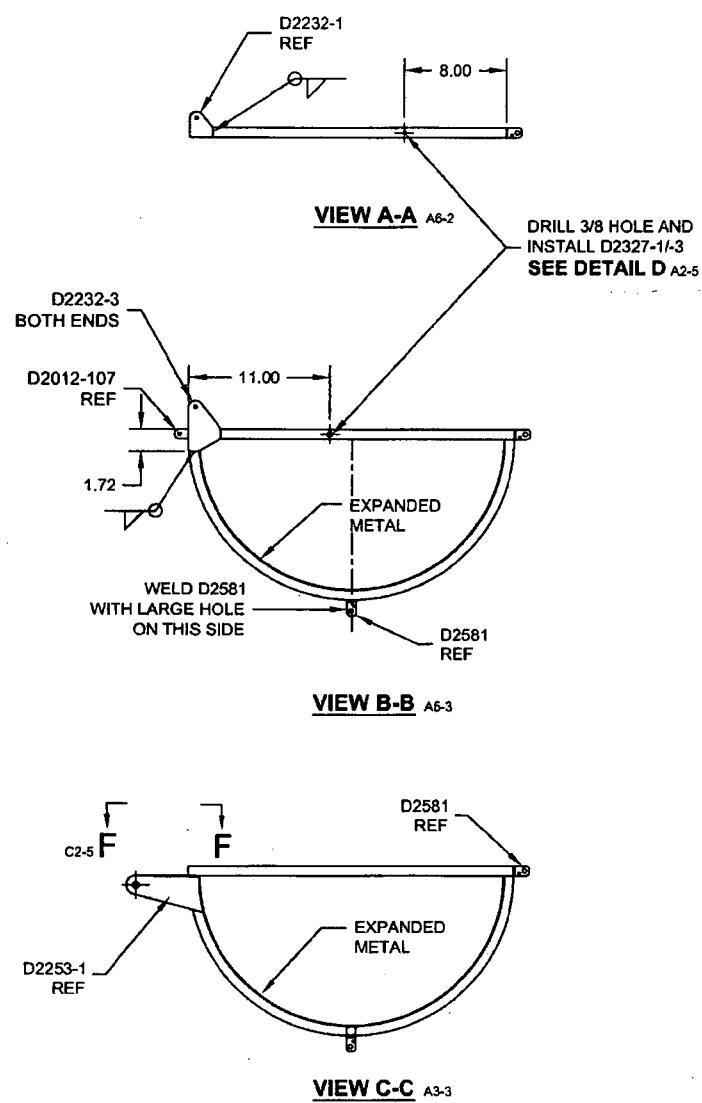
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4

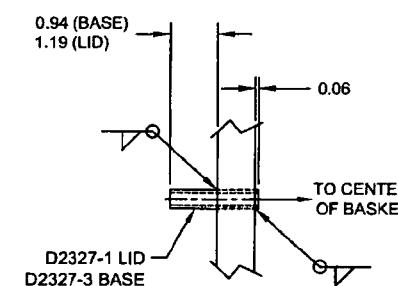
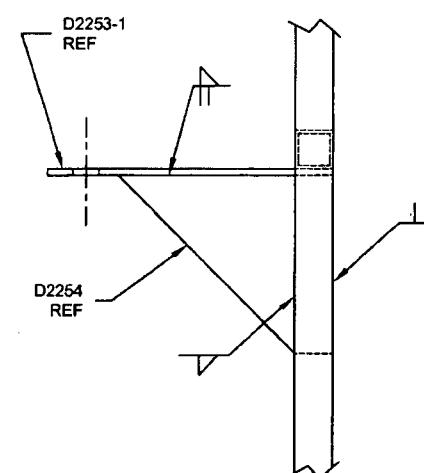
3

2

1



REFERENCE ONLY  
#44222A



**DETAIL D**  
SPACER INSTALLATION  
SCALE 4X

RELEASE  
08/08/11

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS	DRAWING NO. D2330 REV. F SHEET 5 OF 6		
CHECKED		MFG. APPR. <input checked="" type="checkbox"/> APPROVED <input checked="" type="checkbox"/> APPROVED TITLE BASKET ASSEMBLY (206B) SCALE NTS		
APPROVED		DATE 08.08.11		
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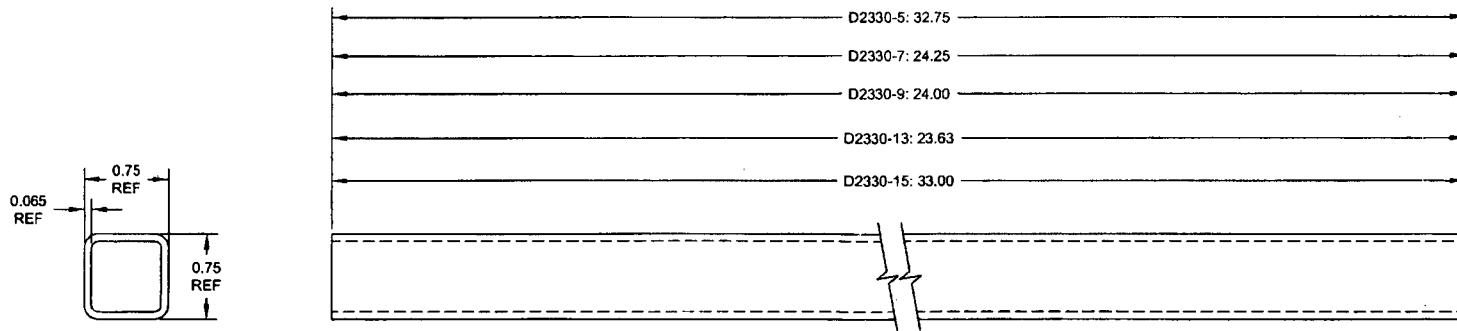
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D2330-5 FRAME

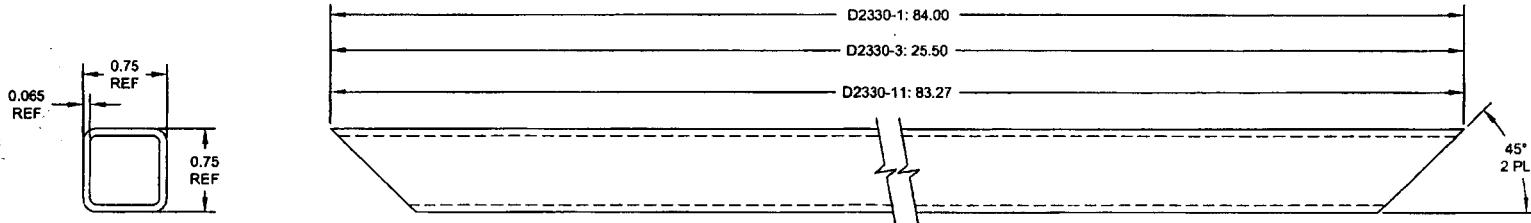
D2330-7 FRAME

D2330-9 FRAME

D2330-11 FRAME

D2330-13 FRAME

D2330-15 FRAME



D2330-1 FRAME

D2330-3 FRAME

D2330-11 FRAME

RELEASED  
08-09-05

NOTES:  
 1) FRAME MATERIAL: SEE SHEET 1  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: N/A

REFERENCE ONLY  
# 44222A

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	A/S	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2330	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NTS
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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